

Date: Monday, 4/24/2006 10:25:21 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: FUEL PURGE CANISTER		
Job Number	: 26761					
Estimate Number	: 10440					
P.O. Number	: N/A			Part Number	: D3262041	
This Issue	: 4/24/2006 S.O. No. : N/A			Drawing Number	: D3262 REV B	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: N/A			Drawing Revision	: B	
Previous Run	: 26416			Material	: N/A	
Written By	: <i>Segi</i> (Comment Below)			Due Date	: 5/15/2006	
Checked & Approved By	: <i>9806104.24</i>			Qty:	2 Um: Each	
Comment	: Est. C 05.03.10 Removed P/O for liquid penetrant inspection K			J/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	26761A	FUEL PURGE CANISTER
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Comment: Sub-Component FUEL PURGE CANISTER

2.0	26761B	FUEL PURGE CANISTER
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Comment: Sub-Component FUEL PURGE CANISTER

3.0	D32621	Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Tube

Pick:

Qty	Part Number	Description	Batch
1	D-3262-1	Tube	<i>26761A</i>

1/06-05-17

2

4.0	D32623	Cap
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Cap

Pick:

Qty	Part Number	Description	Batch
2	D3262-3	Cap	<i>26761B</i>

1/06-05-17

2

5.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

Weld canister assembly as per Dwg D3262 using DT8739 to align fillings

Pick:	Qty	Part Number	Description	Batch
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A/R		Aluminum Rod	<i>m19173</i>
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1/06-05-17

2

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/24/2006 10:25:22 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FUEL PURGE CANISTER

Job Number: 26761

Part Number: D3262041

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5/9

WELD INSPECTION



PD 06-06-05

260605(2)



Comment: WELD INSPECTION

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

H.M 06-06-14

8.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

1-Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3

2-Ensure to mask threads

a.m 06-06-15

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC 06 06 15

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N as per Dwg using a permanent fine point marker, then Stock

Location: */*

SL 06/06/15 (2)

11.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/06/16 (2)

Job Completion



W 06.06.16



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod-Mgr	Approval QC Inspector
06/06/09	6	Add Pressure test as per Dwg to step for inspection. permanent change.	2	06.06.09	2	<i>SD</i> 06/06/09	<i>SD</i> 06/06/09

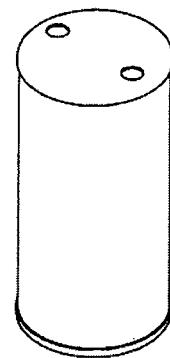
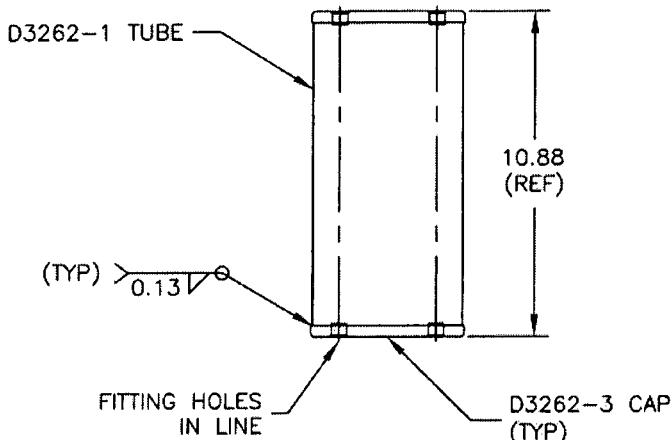
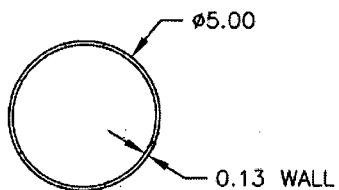
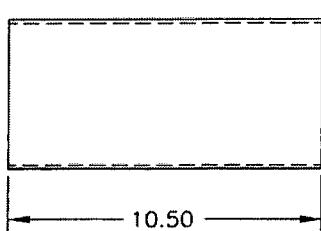
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: *SD* Date: *06/06/16*
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>RF</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3262	REV. B SHEET 1 OF 2
DATE 05.02.14		TITLE FUEL PURGE CANISTER	SCALE 1:1
A	04.05.06	NEW ISSUE	
B	05.02.14	ADD PRESSURE TESTING OPTION	

RELEASED
05.02.14 *[Signature]***D3262-041 CANISTER ASSEMBLY****D3262-1 TUBE****D3262-041:**

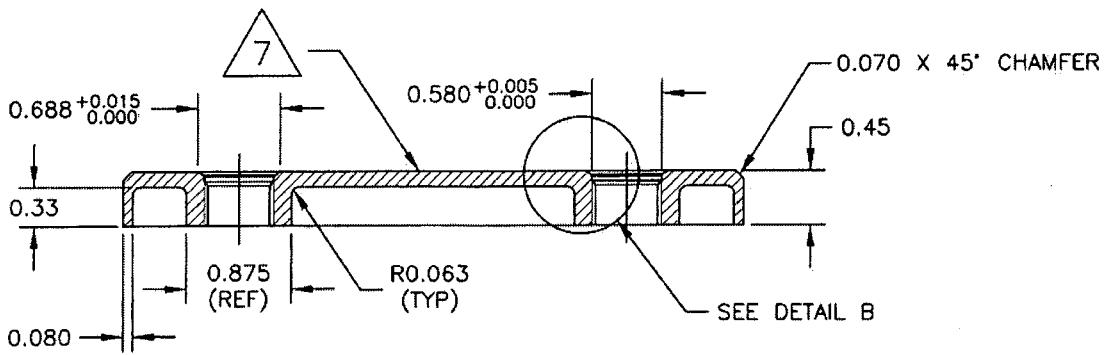
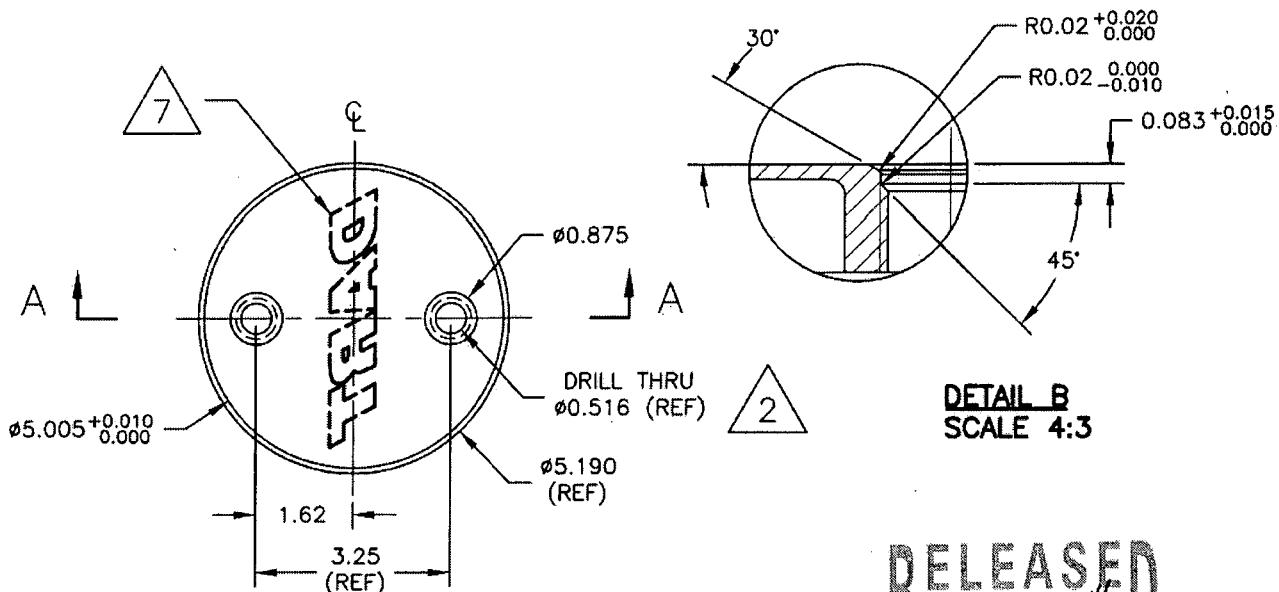
1) MATERIAL: 6061-T6 (WW-T-700/6 OR QQ-A-200/8 OR QQ-A-225/8)
TUBING 5.00 OD x 0.125 WALL (6061T6T5.000W.125)
2) WELD PER QSI 004.
3) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR PRESSURIZE TO 10 ^{PSI} AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS
4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
5) BREAK ALL SHARP EDGES 0.005 TO 0.010
6) ALL DIMENSIONS ARE IN INCHES
7) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
8) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT INK MARKER

SHOP COPY

RETURN TO
ENGINEERINGCONTROLLED COPY
SUBJECT TO AMENDMENTWITHOUT NOTICE
WORK ORDERNO. 26761**B**

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED H	APPROVED H	DRAWING NO. D3262 REV. B SHEET 2 OF 2
DATE 05.02.14		TITLE SCALE FUEL PURGE CANISTER 1:3

**SECTION A-A**
SCALE 2:3**RELEASED**
05.02.14**D3262-3 CAP****D3262-3**

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR
(REF. DART SPEC. M6061T6B)
- 2) TAP HOLE 9/16-18 UNF-3B PER MIL-S-8879
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) PART IS SYMMETRIC ABOUT CENTERLINE
- 7) ENGRAVE DART LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP
(MAX) LETTERS WITH (MIN) TOOL RADIUS OF 0.25

SHOP COPY

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ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER
NO. 26761